

September 06, 2016 1:34:21 PM

Page 1

SEP 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 150788

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150788

Page 2

Item ID: D169-841-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AW169 Upper Cutter Deflector

Start Date: 9/6/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/28/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Packaging

0.00

130

Packaging

Memo

0.00

PPD 150788

SEP 16 2016

28
9-89

Packaging

Identify and pack for shipping as per PPP D169-841-013

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

DAS
21
9-89

SEP 16 2016

Quality Control

16/09/16

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER :																									

Picklist Print

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Page 1

Work Order ID: 150788

150788

Parent Item: D169-841-013

D169-841-013

Parent Item Name: AW169 Upper Cutter Deflector

Start Date: 9/6/2016

Required Date: 11/28/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-07-17 JLM VERIFIED BY:DD IPP
REV:B 13.10.18 IIN REV.B DD VERF:JLM IPP REV:C
15.07.03 AS PER CHG002 ecn15-595 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4821-1

Manufactured

No

Each

9.0000

1

D4821-1

Windshield Deflector

**

DAS
6
9-89

PC

Location

Loc Qty

Loc Code

cck008

9

138600

2

140556

6

140731

1

D4822-1

Manufactured

No

Each

7.0000

1

D4822-1

Upper Deflector, LH

**

DAS
6
9-89

PC

Location

Loc Qty

Loc Code

CCK042

7

138910

7

D4822-2

Manufactured

No

Each

15.0000

1

D4822-2

Upper Right Deflector

**

DAS
6
9-89

PC

Location

Loc Qty

Loc Code

CCK042

15

139056

1

140388

9

140558

5

SEP 17 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
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Past Expiry Date ☐	Manufacturing Process ☐					
Misidentified ☐	Past Due ☐	OTHER :				

Picklist Print

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Page 2

Work Order ID: 150788

150788

Parent Item: D169-841-013

D169-841-013

Parent Item Name: AW169 Upper Cutter Deflector

Start Date: 9/6/2016

Required Date: 11/28/2016

Start Qty: 1.00

Required Qty: 1.00

D4840-041 Manufactured No

Each 1.0000

1

D4840-041

Upper Cutter Assembly

**

Location

Loc Qty

Loc Code

CCK045

1

144078

1

D4857-041 Manufactured No

Each 1.0000

2

D4857-041

Wiper Deflector Assembly

**

Location

Loc Qty

Loc Code

cck136a

1

142166

1

MS27039-1-12 Purchased No

Each 135.0000

8

MS27039-1-12

Screw

**

Location

Loc Qty

Loc Code

ST280

135

m134294

35

m135566

100

DAS
6
9-89

28
9-89

28
9-89

SEP 09 2016
DAS
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9-89

DAS
6
9-89

28
9-89

SEP 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 150788

September 06, 2016 1:34:21 PM

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Item ID: D169-841-013

Revision ID:

Item Name: AW169 Upper Cutter Deflector

Start Date: 9/6/2016 Start Qty: 1.00

Required Date: 11/28/2016 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: SEP 06 2016

SPC (Y/N):

Date:

Date:

QC:

Run Start *NR1*
Stop *NR2*

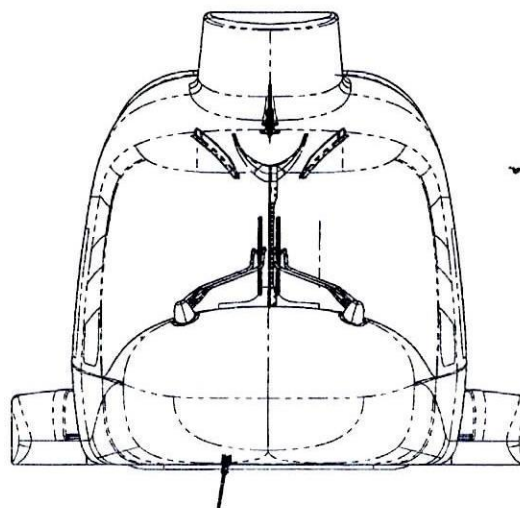
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D169-841	D	0.00							
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo								
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D169-841-013								
		0.00							
110	Pick Kit	0.00							
110									
Packaging	Memo								
Packaging									
		0.00							
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo								
Quality Control									

DAS
21
9-89

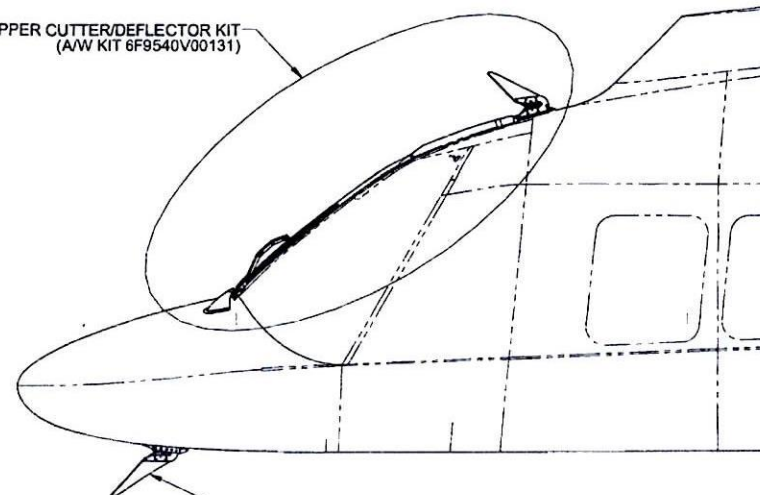
SEP 07 2016

REFERENCE ONLY

28
9-89



D169-841-013 UPPER CUTTER/DEFLECTOR KIT
(AW KIT 6F9540V00131)



D169-841-015 LOWER CUTTER KIT
(AW KIT 6F9540V00231)

D169-841-011 AW169 CABLE CUTTER SYSTEM

QTY -011	QTY -013	QTY -015	DART P/N	DESCRIPTION	AGUSTA WESTLAND P/N
X			D169-841-011	CABLE CUTTER SYSTEM	TBD
1	X		D169-841-013	UPPER CUTTER/DEFLECTOR KIT	6F9540V00131
1		X	D169-841-015	LOWER CUTTER KIT	6F9540V00231
	1		D4821-1	WINDSHIELD DEFLECTOR	TBD
	1		D4822-1	UPPER DEFLECTOR LH	TBD
	1		D4822-2	UPPER DEFLECTOR RH	TBD
	1		D4840-041	UPPER CUTTER ASSY	TBD
	2		D4857-041	WIPER DEFLECTOR ASSY	TBD
	8		MS27039-1-12	SCREW	N/A
	TBD		TBD	FASTENERS	N/A
		1	D4842-041	LOWER CUTTER ASSY	TBD
		5	MS21042L08	LOCKNUT	N/A
		5	MS27039-0824	SCREW	N/A
		10	NAS1149FN832P	WASHER	N/A

D	MS27039-0824 WAS MS27039-0819. REFORMAT PARTS LIST.	AJS	15.06.12
C	D4857-041 WAS D4857-1 (D4944-1 GASKETS NOW IN D4857 DRAWING). PARTS LIST: MS27039-1-12 QTY WAS 10	AJS	15.05.20
B	ADD D4944-1 GASKET (ZN A8-1) (ZN B8-2, B8-2) ADD MS27039-1-12 SCREW. D4857-1 WAS D4857-041-042	DW	13.09.23
A	NEW RELEASE	DB	13.07.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. D
MFG. APPR.	JLM	IIN-D169-841	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	AW169 CABLE CUTTER SYSTEM	NTS
DATE	15.06.12	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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